

Work Order ID 68113

Wednesday, April 06, 2011 2:58:13 PM



Page 1

Item ID: D206-628-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 4/6/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| N/A | Rev N/A |

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-033 CHG 002

8/11/11

for CL 11-5-13

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/5/17 SP 30

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/11/11

*+3
44*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

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Item ID: D206-628-033

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Start Date: 4/6/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------|
| 130 | Packaging | 0.00 | | | | 11/5/18 SP | | | (30) |
| Packaging | Memo Identify and pack for shipping as per PPP D206-628-033 Location: <u> </u> PPP Rev: <u>70</u> | 0.00 | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | 11/5/18 20 |
| QC Quality Control | Memo | 0.00 | | | | | | | 11-05-18 (3) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 68113

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH






Start Date: 4/6/2011

Required Date: 4/14/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| AN3C4A  BOLT | | Purchased | No | | | 110 | Each | 2,408.000 | 3 | 9 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | ST350 | | 2408 | | | | | | | |
| | | | | 116924 | | 408 | | | | | | | |
| | | | | 117094 | | 1000 | | | | | | | |
| | | | | 117313 | | 1000 | | | | | | | |
| AN4C14A  Bolt | | Purchased | No | | | 110 | Each | 6.0000 | 8 | 24 | 10x | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | ST358 | | 6 | | | | | | | |
| | | | | 115936 | | 6 | | | | | | | |
| AN4C15A  Bolt | | Purchased | No | | | 110 | Each | 46.0000 | 4 | 12 | 4x | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | ST358 | | 46 | | | | | | | |
| | | | | 115936 | | 46 | | | | | | | |
| AN960C10  WASHER | NAS1149C0363 R | Purchased | No | | | 110 | Each | 0.0000 | 3 | 9 | | | |
| AN960C416L  WASHER | | Purchased | No | | | 110 | Each | 0.0000 | 24 | 72 | | | |

NAS1149 C0432R

M117206
M117441
M114742
M116900 11/6/17SL (3D)

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 68113

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH

Start Date: 4/6/2011

Required Date: 4/14/2011

Start Qty: 3.00

Required Qty: 3.00

D2731-3 Manufactured No

110 Each

116.0000

4

S
3
Mounting Lug

Location

Loc Qty

Loc Code

ST469

116

47967

77

52329

39

12

D2732 Manufactured No

110 f

388.0000

2

S
3
Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

388

64283

388

6/1

D2842-041 Manufactured No

110 Each

0.0000

1

S
3
5
Step Assembly, 206 Float

D2844-1 Manufactured No

110 Each

11.0000

2

S
3
Arm

Location

Loc Qty

Loc Code

ST265

11

62954

11

6/1

B68114

6

B68115

D2844-3 Manufactured No

110 Each

19.0000

1

S
3
Arm

Location

Loc Qty

Loc Code

ST265

7

62967

7

ST266

12

66822

12

3

11/5/17

30

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Shop Packet Print

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| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, April 06, 2011 2:58:20 PM

Work Order ID: 68113

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH

Start Date: 4/6/2011

Required Date: 4/14/2011

Start Qty: 3.00

Required Qty: 3.00

D3394-041

Manufactured No

110 Each

39.0000

4

12



Lug Assembly

Location

Loc Qty

Loc Code

MEZZ

39

47970

3

56528

36

Purchased No

110 Each

658.0000

12

36

MS21043-4



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

618

116188

318

116549

300

Purchased No

110 Each

103.0000

3

9

NAS1515H3



Washer

Location

Loc Qty

Loc Code

ST277

103

115935

3

116373

100

Purchased No

110 Each

40.0000

24

72

NAS1515H4L



WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

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| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

| Qty -013 | Qty -014 | Qty -023 | Qty -024 | Qty -033 | Qty -034 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|--------------|------------------------------------|
| X | | | | | | D206-628-013 | 206 A/B FLOAT STEP INST. LH |
| | X | | | | | D206-628-014 | 206 A/B FLOAT STEP INST. RH |
| | | X | | | | D206-628-023 | 206 L/L1/L3/L4 FLOAT STEP INST. LH |
| | | | X | | | D206-628-024 | 206 L/L1/L3/L4 FLOAT STEP INST. RH |
| | | | | X | | D206-628-033 | 407 FLOAT STEP INST. LH |
| | | | | | X | D206-628-034 | 407 FLOAT STEP INST. RH |
| 2 | 2 | | | 4 | 4 | D2731-3 | MOUNTING LUG |
| 2 | 2 | 4 | 4 | | | D2731-7 | MOUNTING LUG |
| 8 | 8 | 8 | 8 | 8 | 8 | D2732-030 | RUBBER CUSHION |
| 1 | | | | | | D2841-041 | FLOAT STEP ASSEMBLY LH |
| | 1 | | | | | D2841-042 | FLOAT STEP ASSEMBLY RH |
| | | 1 | | 1 | | D2842-041 | FLOAT STEP ASSEMBLY LH |
| | | | 1 | | 1 | D2842-042 | FLOAT STEP ASSEMBLY RH |
| | | 2 | 2 | 2 | 2 | D2844-1 | ARM |
| | | 1 | 1 | 1 | 1 | D2844-3 | ARM |
| 2 | 2 | | | | | D2845 | ARM |
| 2 | 2 | | | 4 | 4 | D3394-041 | MOUNTING LUG |
| 2 | 2 | | | 4 | 4 | *D3394-1 | *MOUNTING LUG |
| 4 | 4 | | | 8 | 8 | *MS35489-93 | *GROMMET |
| 2 | 2 | 4 | 4 | | | D3394-043 | MOUNTING LUG |
| 2 | 2 | 4 | 4 | | | *D3394-3 | *MOUNTING LUG |
| 4 | 4 | 8 | 8 | | | *MS35489-93 | *GROMMET |
| 2 | 2 | 3 | 3 | 3 | 3 | AN3C4A | BOLT |
| 4 | 4 | | | | | AN4C13A | BOLT |
| 4 | 4 | 4 | 4 | 8 | 8 | AN4C14A | BOLT |
| 4 | 4 | 8 | 8 | 4 | 4 | AN4C15A | BOLT |
| 2 | 2 | 3 | 3 | 3 | 3 | AN960C10 | WASHER |
| 24 | 24 | 24 | 24 | 24 | 24 | AN960C416L | WASHER |
| 24 | 24 | 24 | 24 | 24 | 24 | NAS1515H4L | WASHER |
| 12 | 12 | 12 | 12 | 12 | 12 | MS21043-4 | NUT |
| 2 | 2 | 3 | 3 | 3 | 3 | NAS1515H3 | WASHER |

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

